

Work Order ID 60076

June 24, 2010 9:05:26 AM



Page 1

Item ID: D3245-043

Accept



Setup Start



Revision ID:

Item Name: Door Assembly

Stop



Start Date: 6/24/10 Start Qty: 4.00



Cust Item ID:

Required Date: 7/02/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3245

Rev B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

SB 10/27/21

(4)

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Install Studs and Gromets as per Dwg D3245-3-Bond Gasket using 3M ADHESIVE as per Dwg D3245-A/R 3M 1300/1300L ADHESIVE
Batch: *M113124*

SB 10/27/21

(4)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 10/27/21

(4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60076

June 24, 2010 9:05:26 AM



Page 2

Item ID: D3245-043

Accept

Revision ID:

Item Name: Door Assembly

Start Date: 6/24/10 Start Qty: 4.00

Required Date: 7/02/10 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location 232

0.00

Memo

0.00

10-7-20

42

SP

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/07/23

mr

10-7-22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 24, 2010 9:05:25 AM

Page 1

Work Order ID: 60076

Parent Item: D3245-043

Parent Item Name: Door Assembly


Start Date: 6/24/10

Required Date: 7/02/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue 07-09-11 JLM Verified By:EC
IPP Rev:b ECN 1052 07-10-31 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
127H-35  HALF GROMMET		Purchased	No			100	Each	37.0000	8	32			

Location

Loc Qty

Loc Code

ST398

37 M110279

111581

2351-20-009-C3Y

Purchased

No

110

Each

182.0000

8

32

STUD

Location

Loc Qty

Loc Code

ST399

182

106484

1

110944

75

111733

100

15447

6

D3245-3

Manufactured

No

110

Each

5.0000

1

4

Door

Location

Loc Qty

Loc Code

ST233A

5

40201

1

47689

4

20
30 12 SS 10/07/21 (4)
25 25 SS 10/07/21 (4)
4 SS 10/07/21 (4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 24, 2010 9:05:26 AM

Page 2

Work Order ID: 60076

Parent Item: D3245-043

Parent Item Name: Door Assembly



Start Date: 6/24/10

Required Date: 7/02/10

Start Qty: 4.00

Required Qty: 4.00

D3245-7

Manufactured No

110

Each

7.0000

1

4



Gasket



Location

Loc Qty

Loc Code

ST233B

7

36018

3

46175

4

3

SB 10/02/10

(4)

June 24, 2010 9:05:26 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

2350-18-C3Y DZUS
RIGID RECEPTACLE (1)
MS20427M3-3 RIVET (2)
(8 PLACES)

D3245-041 ACCESS PANEL ASSEMBLY

D3245-042 ACCESS PANEL ASSEMBLY

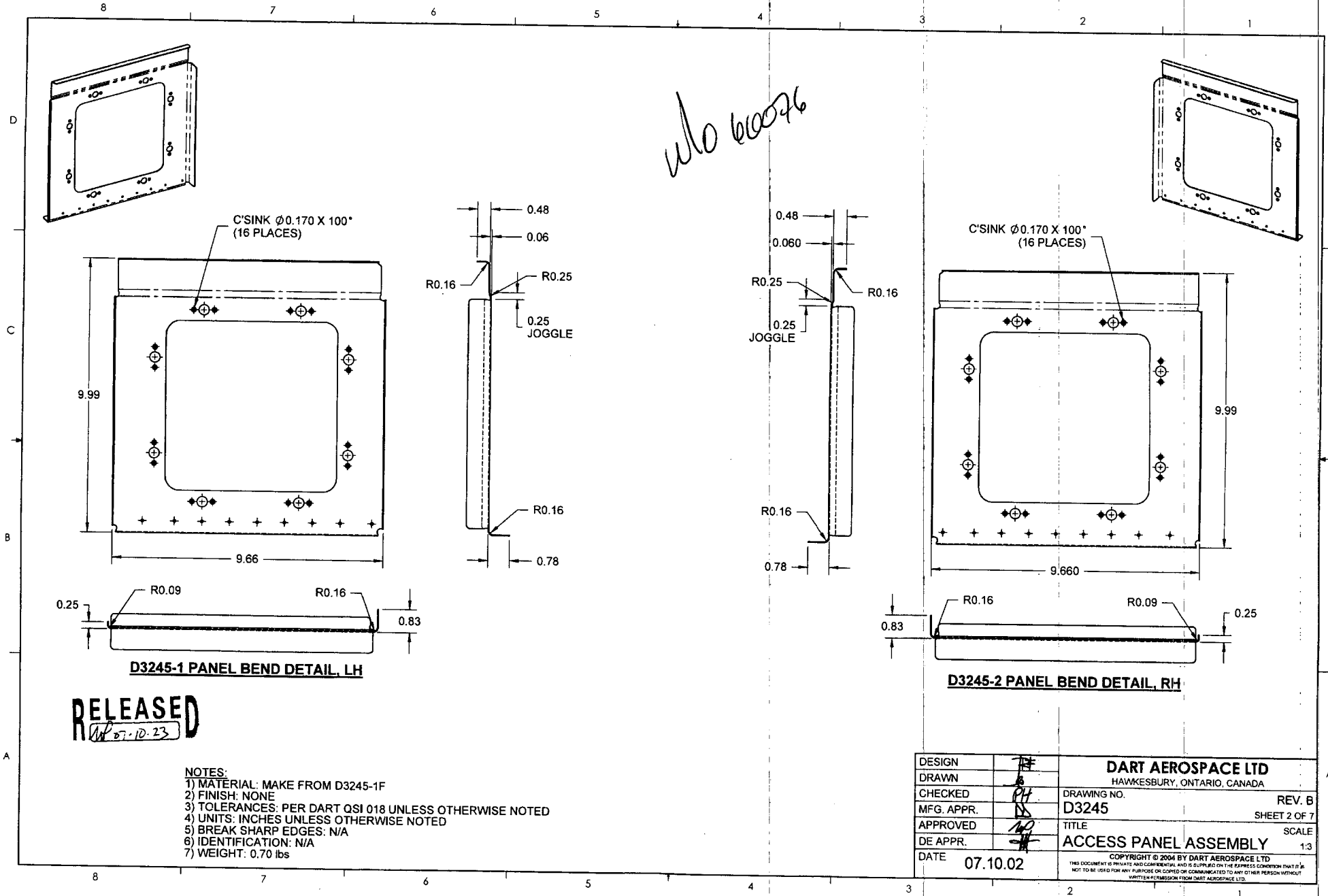
QTY -041	QTY -042	P/N	DESCRIPTION
X	X	D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
1	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

NOTES:

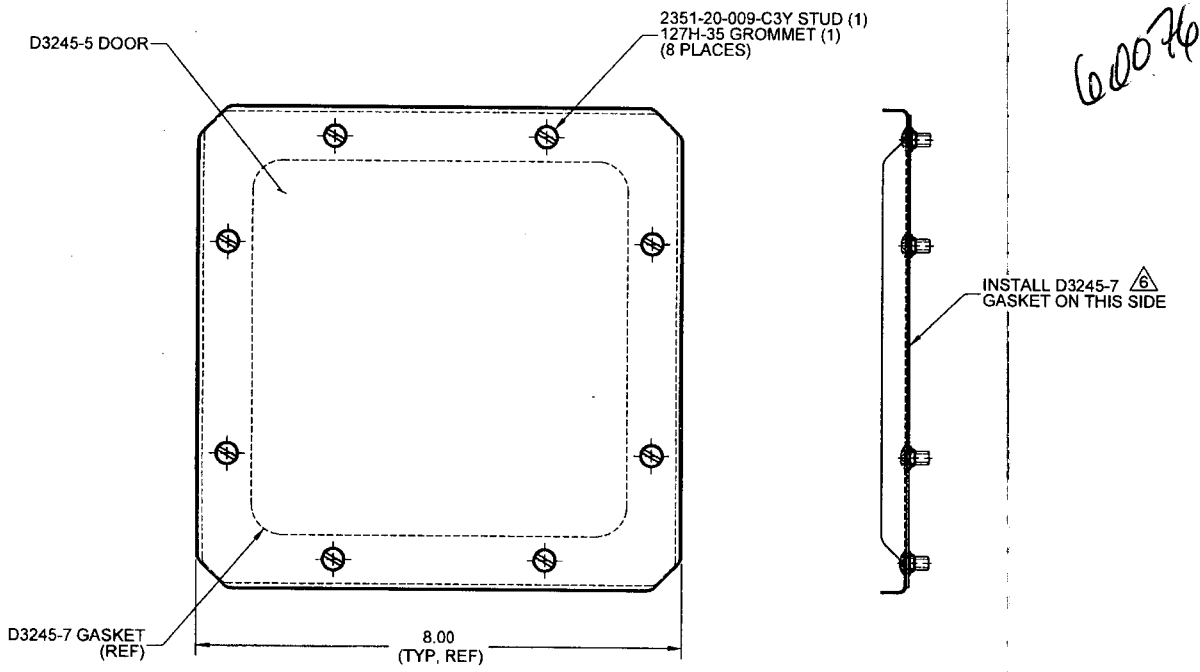
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

RELEASED
11/07/10

B		REMOVE Ø0.204 HOLES FROM D3245-17-1F. REMOVE MS21060L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING.		MB	07.10.02
A		NEW ISSUE		RF	04.01.27
REV.	DESCRIPTION			BY	DATE
DESIGN	DART AEROSPACE LTD			REV. B	
DRAWN	HAWKESBURY, ONTARIO, CANADA			SHEET 1 OF 7	
CHECKED	DRAWING NO. D3245			SCALE	
MFG. APPR.	TITLE			1:2.5	
APPROVED	ACCESS PANEL ASSEMBLY				
DE APPR.	COPYRIGHT © 2004 BY DART AEROSPACE LTD				
DATE	07.10.02			THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



8 7 6 5 4 3 2 1



D3245-043 DOOR ASSEMBLY

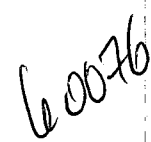
QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

RELEASED
27-10-23

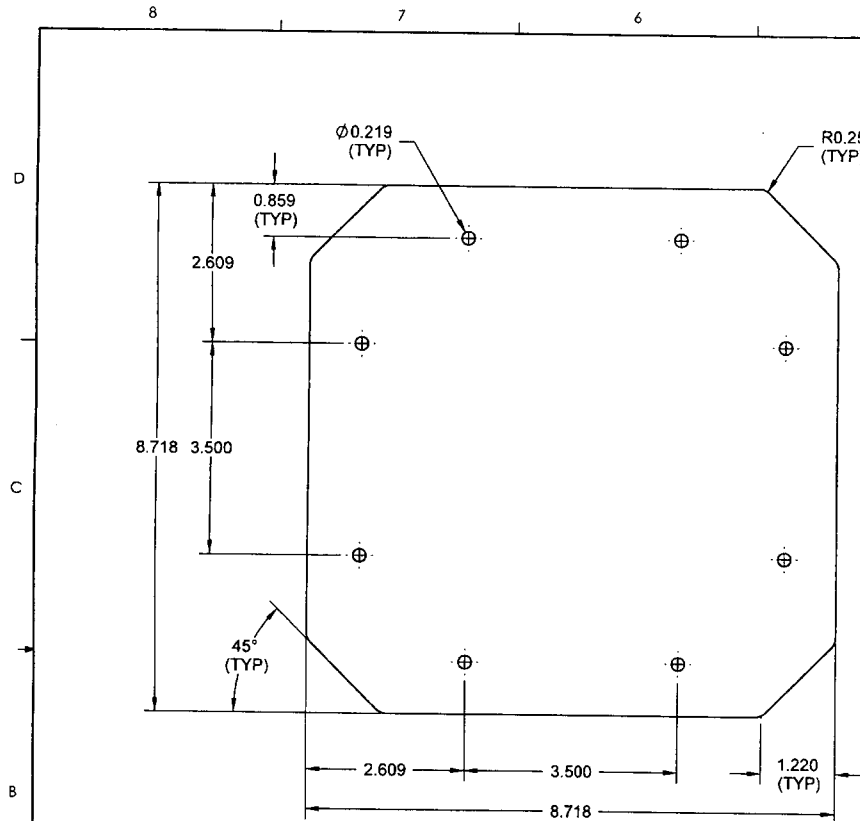
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
 - 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
 - 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
 - 9) WEIGHT: 0.73 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3245	SHEET 3 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ACCESS PANEL ASSEMBLY	1:2
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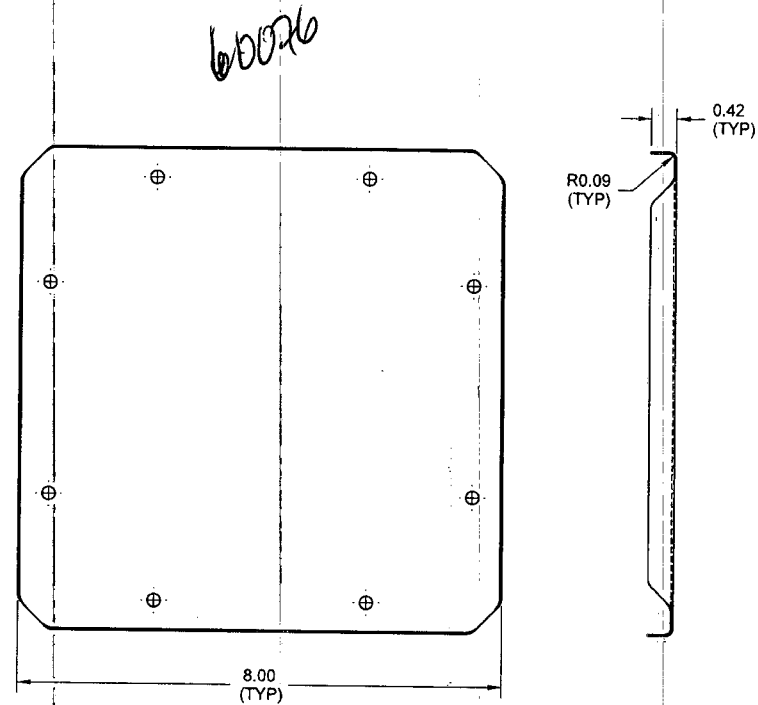
8 7 6 5 4 3 2 1



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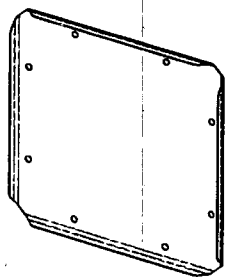
D3245-3F DOOR FLAT PATTERN









D3245-3 DOOR BENDING DETAIL

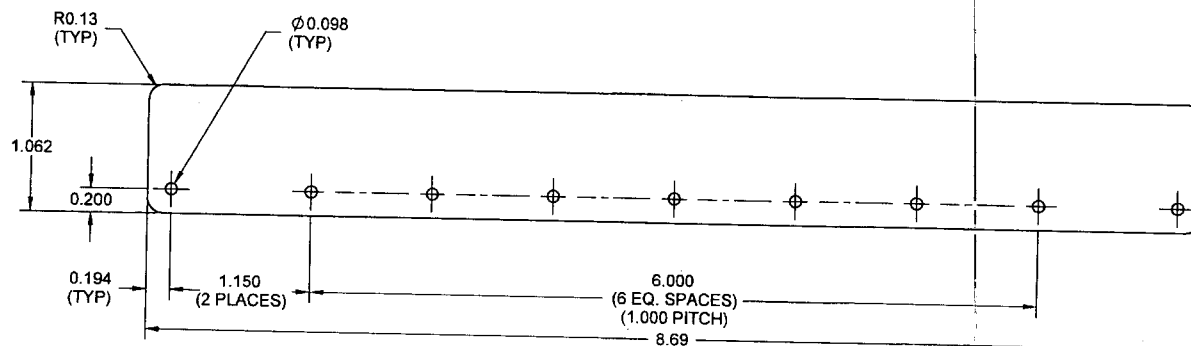
RELEASED
07.10.02

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.67 lbs

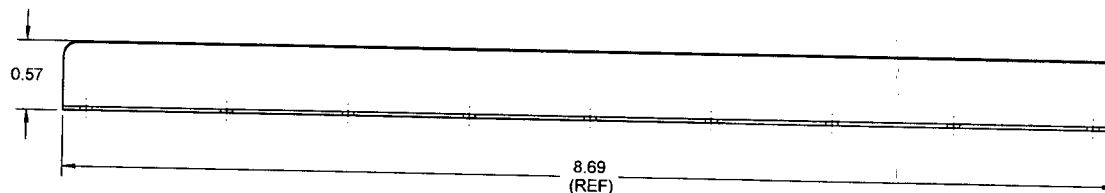


DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3245	SHEET 5 OF 7
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSEMBLY	1:2
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8 7 6 5 4 3 2 1



D3245-5F FLAT PATTERN



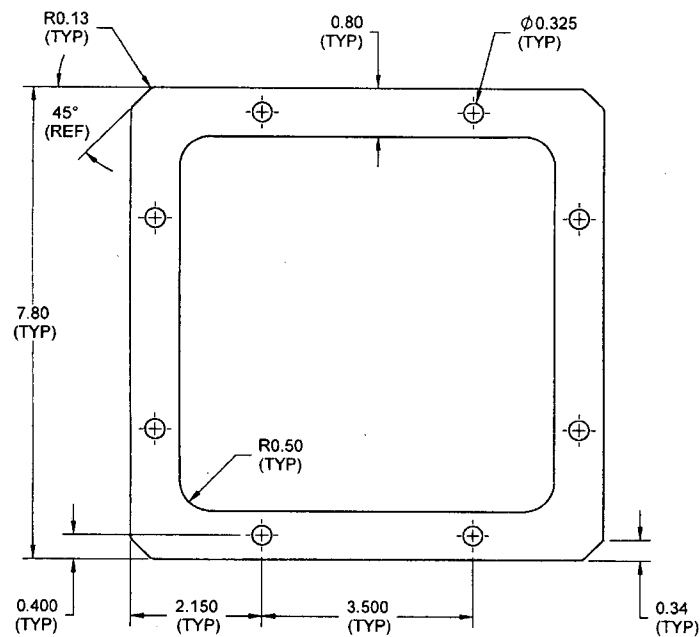
D3245-5 BEND DETAIL
(MAKE FROM D3245-5F)

RELEASED
07.10.23

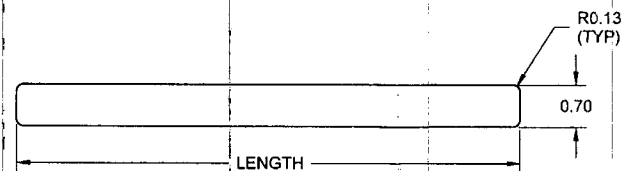
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3245	SHEET 6 OF 7
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSEMBLY	1:1
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D3245-7 GASKET



D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

60076

RELEASED
07.10.02

NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK
(PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3245	SHEET 7 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ACCESS PANEL ASSEMBLY	
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